



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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6F9540V00231

Job Sheet 200502



concession # 40000087063

Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 11/8/19

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		11/8/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		



Container No: S227629



Part: 6F9540V00231

Job No: 200502

Serial No/Batch: S227629

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/29/19

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Plex 9/12/19 9:14 AM Dart.Renwick.Jennifer

					Packaging 1 - 28	
					Packaging 1 - 29	
					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					QC 4 - 28	
170 QC 4	1 pcs	11/8/19	0.00	0.00	QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
180 Packaging 3-1 - Stock - B4B	1 pcs	11/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

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190 DC - 1 - B4B	1 pcs	11/8/19	0.00 0.00	DC - 1 - B4B	21	NOV 04 2019
				DC - 2 - B4B	21	
200 QC 21 - FG	1 pcs	11/8/19	0.00 0.00	QC 21 - FG - 21	21	NOV 04 2019
				QC 21 - FG - 70	21	
				QC 21 - FG - 53	21	

Part Op 100 - (Pick Kit)

Descriptions: 170 - (QC4- 100% Inspect kits for completeness)

180 - Identify and pack for shipping as per PPP 6F9540V00231

190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5227102

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.

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 LEONARDO S.p.A.	Concessione Fornitore		PAGINA 2 di 2	STAB. EMITTENTE Vergiate
NC Fornitore N.: AWC-030	Data 05.11.2019	Concessione 40000087063	Ordine	4801839434
CAUSE DEL DIFETTO				
* CICS Metodo e Processi				
VALUTAZIONI DELL'ENGINEERING				
* In the attached supplier document.				

		CONCESSION				Pag. 1 of 2	
Manuf. Doc. N.	AWC-030	Date	Oct 30, 2019	AW Doc. N.	400000087063	Purchase Order	4801939434
AW P/N	6F9540100231	S/N / Batch Number	S227629	Grade	A	AW Drawing Issue	B
Description	Protector, CCP Lower Assembly			Batch Qty	1	Defective Qty	1
Manufacturer	Dart Aerospace LTD			Model	AW169		
Defect(s) Description							
- Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 (D4842-3 and D4842-4) onto the Leonardo interface bracket - The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
		Department	Inspector	Signature	Date		
		Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019		
Defect(s) Cause							
- The Lower Cutter body has a dimension of 0.43 +0.01/-0.00. This dimension was reported as part of the approved FAI and has been met with all delivered product - Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
		Department	Inspector	Signature	Date		
		Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019		
Corrective Action				Complete Before			
- In order to mitigate the interference issue for Leonardo, Dart is proposing removing 0.010" (0.254 mm) from each face of the lower cutter body for a total gain of 0.020" (0.508 mm). - Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
		Department	Inspector	Signature	Date		
		Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019		

For "MANUFACTURER" SUPPLIERS ONLY

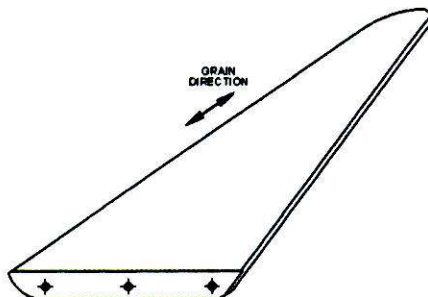
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report
Compliance report

n: NCR18-6764
n...N/A.....

1. Dart's position is that this change will not impact the structural substantiation presented in Report DA189-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.010" from each part will not impact the structural integrity of the lower cutter assembly. With the tolerance stack-up the lower cutter body would measure 0.84" (21.34 mm) to 0.88" (22.35 mm) which provides an additional 0.002" for variance of the sealant.
2. Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



	Defect effects		Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal		Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap	
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no